

Date:
User:Tuesday, 23/09/2008 1:24:39 PM
Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: TURNING DETAIL FOR D2893-1
Job Number	: 42259		
Estimate Number	: 13234		
P.O. Number	:	Part Number	: DSK078
This Issue	: 23/09/2008 S.O. No. :	Drawing Number	: DSK078 REV.A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: // Type : MACHINED PARTS	Drawing Revision	: A
Previous Run	: 40802	Material	:
Written By	:	Due Date	: 30/09/2008 Qty: 10 Um: Each
Checked & Approved By	: <u>JUD 08.9.23</u>		
Comment	: est rev A. 08.03.13 new issue EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D6104005	Round Billet, 17-4
		B 41966
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)	J.F. - 08/10/06 (10)
	Support	
2.0	MORI SEIKI	MORI SEIKI CNC LATHE LARGE
	Comment: MORI SEIKI CNC LATHE LARGE DOOSAN	J.F. 08/10/06 (10)
	Turn blank as per Folio FA081	
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
	Comment: INSPECT PARTS AS THEY COME OFF MACHINE	J.F. 08/10/06 (10)
4.0	QC8	SECOND CHECK
	Comment: SECOND CHECK	SA 08/10/06 (10)
5.0	PACKAGING 1	PACKAGING RESOURCE #1
	Comment: PACKAGING RESOURCE #1	J.F. 08/10/06 (10)
	Identify and Stock in Kanban	
	Location: <u>CNC</u>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 23/09/2008 1:24:39 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TURNING DETAIL FOR D2893-1

Job Number: 42259

Part Number: DSK078

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



08/10/08 *[Signature]*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-10-08 -07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 42259
Description: Turning Detail for D2893-1		Part Number: DSK078
Inspection Dwg: DSK078	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
Lathe Section								
A	2.707	2.712		2.709	2.708	2.708	2.708	2.708
B	4.946	4.966		4.956	4.961	4.960	4.958	4.962
C	3.064	3.084		3.074	3.075	3.074	3.074	3.074
D	0.718	0.738		.726	.726	.726	.726	.726
E	0.090	0.110		.101	.101	.101	.101	.101
F	2.934	2.954		2.944	2.944	2.944	2.944	2.944
G	2.166	2.186		2.176	2.176	2.176	2.170	2.173
H	3.890	3.910		3.898	3.898	3.898	3.897	3.898
I	0.914	0.934		.923	.923	.923	.923	.923
J	0.022	0.042		.032	.032	.032	.032	.032
K	0.109	0.129		.119	.119	.119	.119	.118
L								
M								
N								
O								
P								

Measured by: J.F.	Date: 08/10/06
Audited by: SA	Date: 08/10/06
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	08.04.22	New Issue	KJ/JLM	

DART AEROSPACE LTD		Work Order: 42259
Description: Turning Detail for D2893-1		Part Number: DSK078
Inspection Dwg: DSK078	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	#6	#7	#8	#9	#10
Lathe Section								
A	2.707	2.712		2.708"	2.709"	2.708"	2.708"	2.709"
B	4.946	4.966		4.961"	4.959"	4.962"	4.962"	4.962"
C	3.064	3.084		3.075"	3.075"	3.075"	3.075"	3.075"
D	0.718	0.738		.727"	.727"	.727"	.727"	.727"
E	0.090	0.110		.099"	.100"	.100"	.100"	.100"
F	2.934	2.954		2.944"	2.945"	2.944"	2.944"	2.944"
G	2.166	2.186		2.176"	2.176"	2.176"	2.175"	2.176"
H	3.890	3.910		3.899"	3.898"	3.899"	3.900"	3.899"
I	0.914	0.934		.923"	.923"	.923"	.924"	.924"
J	0.022	0.042		.032"	.032"	.032"	.032"	.032"
K	0.109	0.129		.118"	.118"	.118"	.118"	.118"
L								
M								
N								
O								
P								

Measured by: J.F. Date: 08/10/06

Audited by: SA Date: 08/10/06

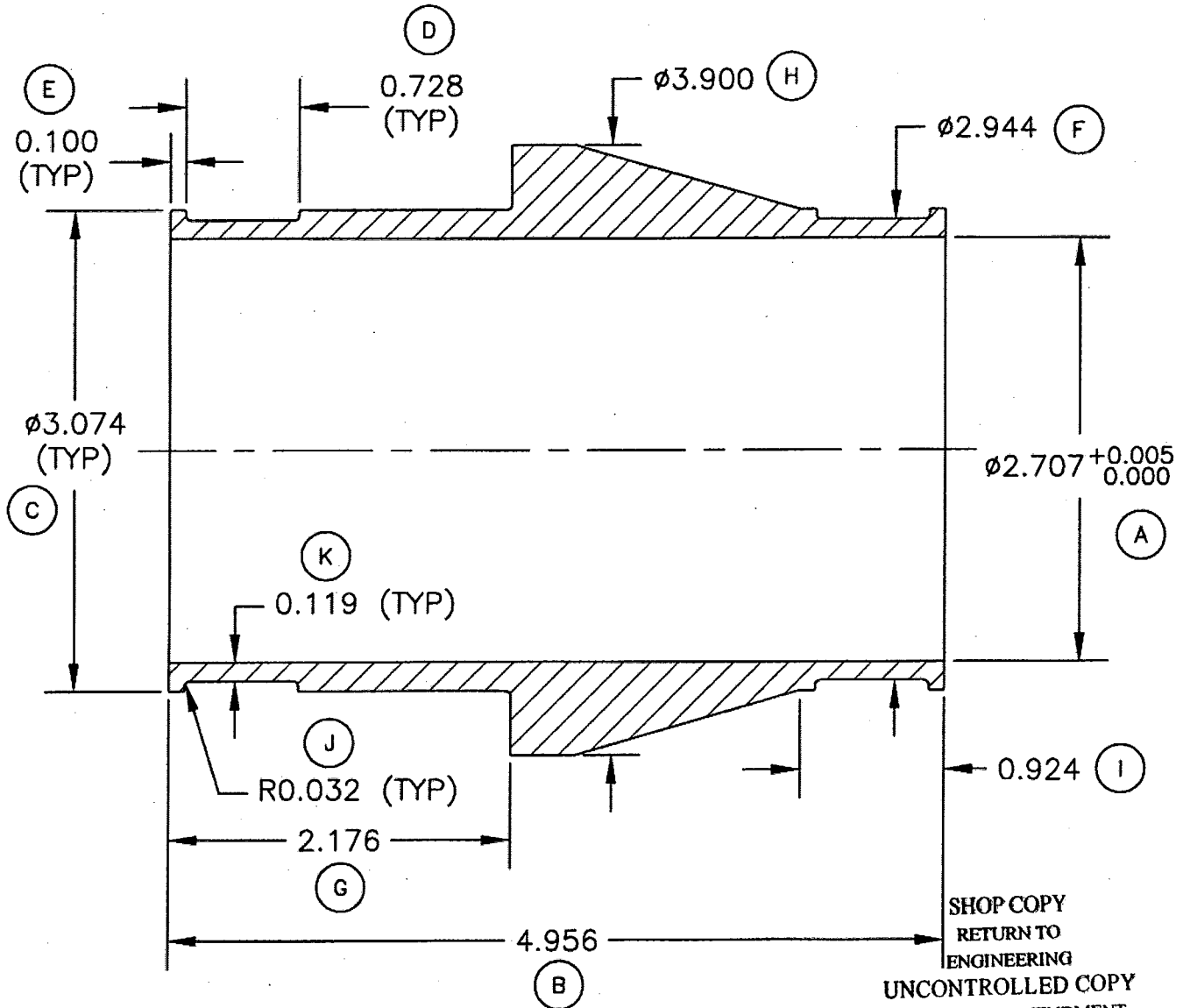
Prototype Approval: Date:

Rev	Date	Change	Revised by	Approved
A	08.04.22	New Issue	KJ/JLM	



DESIGN RT	DRAWN BY RT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. DSK 078	REV. A SHEET 1 OF 1
DATE 03.05.20		TITLE TURNING DETAIL FOR D2893-1	SCALE 1:1
A	03.05.20	NEW ISSUE	

RELEASED
03.07.01



D2893-1 TURNING DETAIL

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 42251

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